

Date: Thursday, 4/12/2007 9:41:53 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 31800	
Estimate Number : 12450	
P.O. Number : <u>N/A</u>	Part Number : D351611
This Issue : 4/12/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3516 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 31626	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 4/30/2007 Qty: 20 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 06-06-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0218 sf(s)/Unit Total : 0.4368 sf(s)

304/316 .125 Sheet 11GA

(M304S11GA)

Batch: ML 02 817

ML 07 05 03

(20)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3516

Dwg Rev: B

Prog Rev: B

ML 07 05 03

(20)

2-Deburr if necessary

SAD. 07/05/07

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 07 05 03

(20)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

[Signature]

(20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3516

SB 07/05/07

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/09

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:41:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 31800

Part Number: D351611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: WS

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CL 7105108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

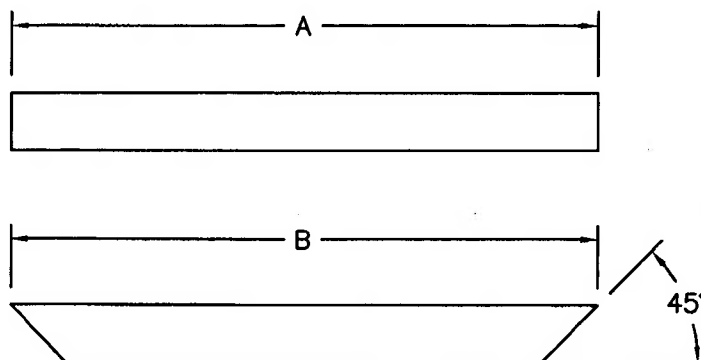
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

RELEASED

06.11.28 *[Signature]***PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

B {

**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING (REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

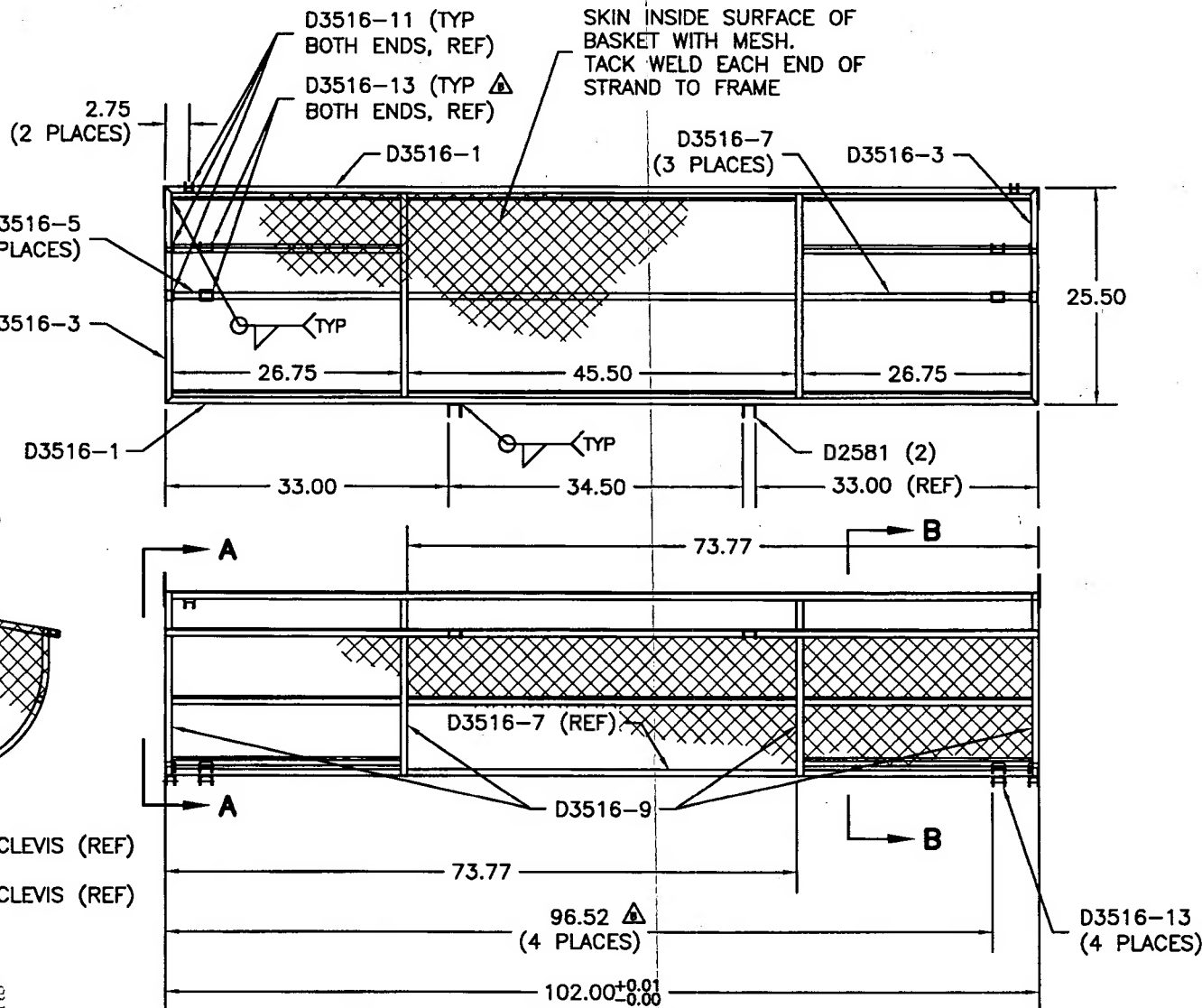
31800

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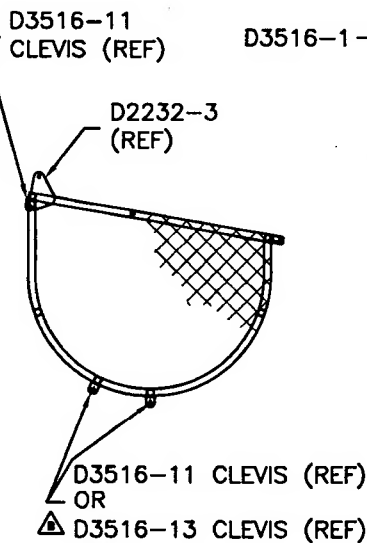
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 5
DATE	TITLE	DRAWING NO.	SCALE
06.07.25	BASKET BASE ASSEMBLY (A119)	D3516	1:20



D3516-041 BASKET BASE ASSEMBLY

RELEASED

06.11.28



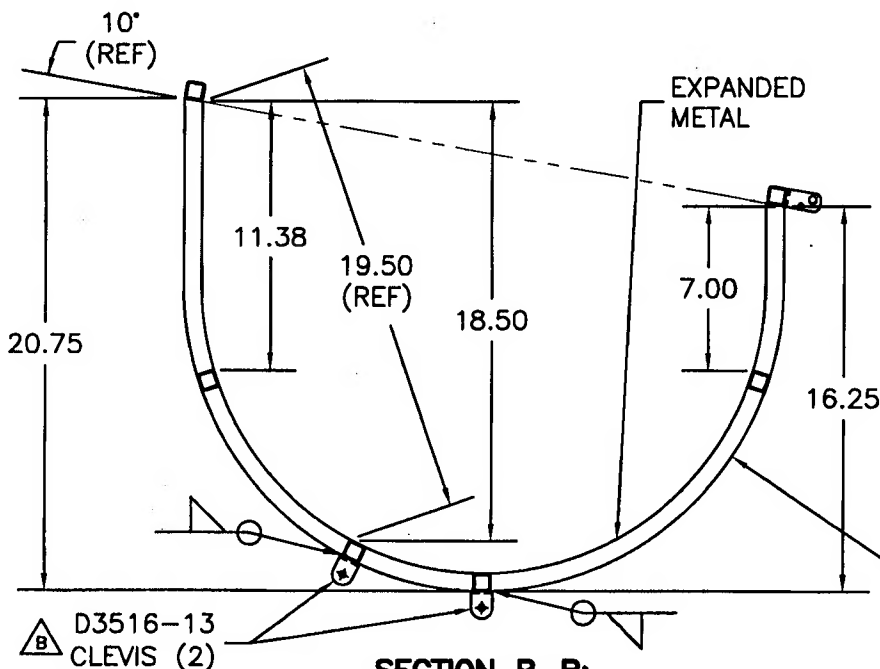
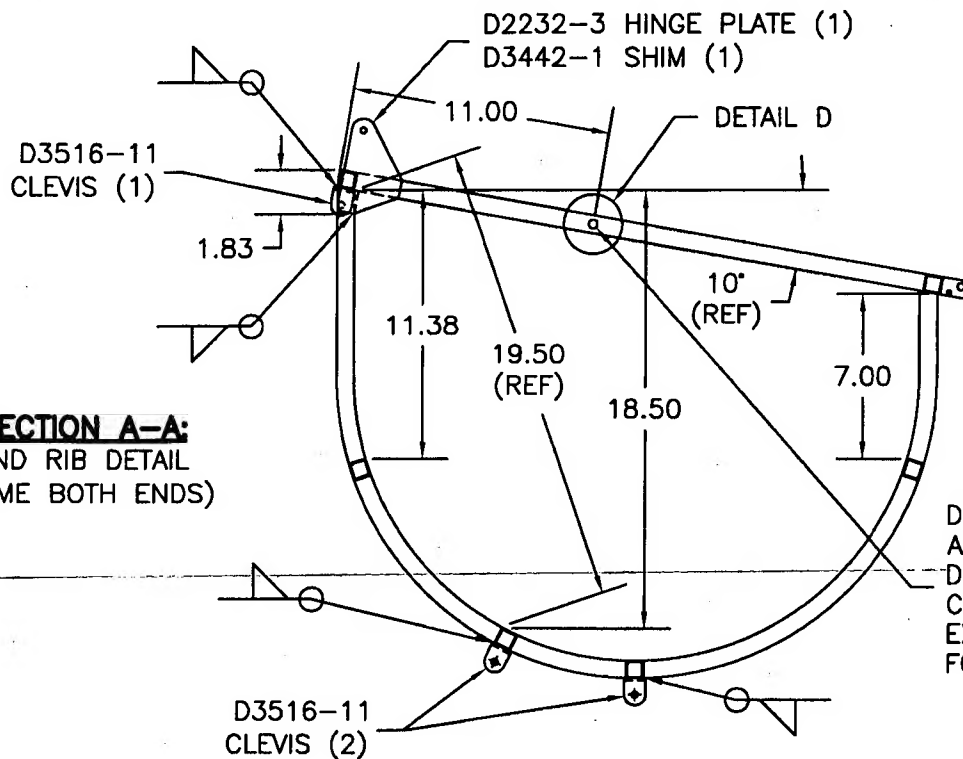
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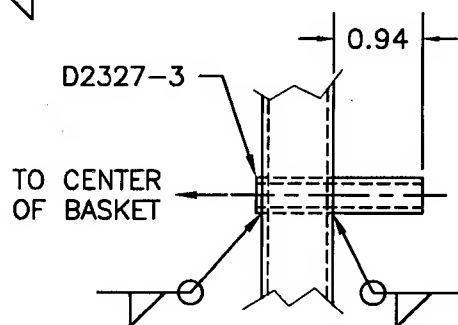
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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:8

SECTION A-A:
END RIB DETAIL
(SAME BOTH ENDS)



SECTION B-B:
CENTER RIB DETAIL
(2 PLACES)



DETAIL D

RELEASED

06.11.28 *[Signature]*

D3516-9 RIB
(MAKE FROM D2235-3)

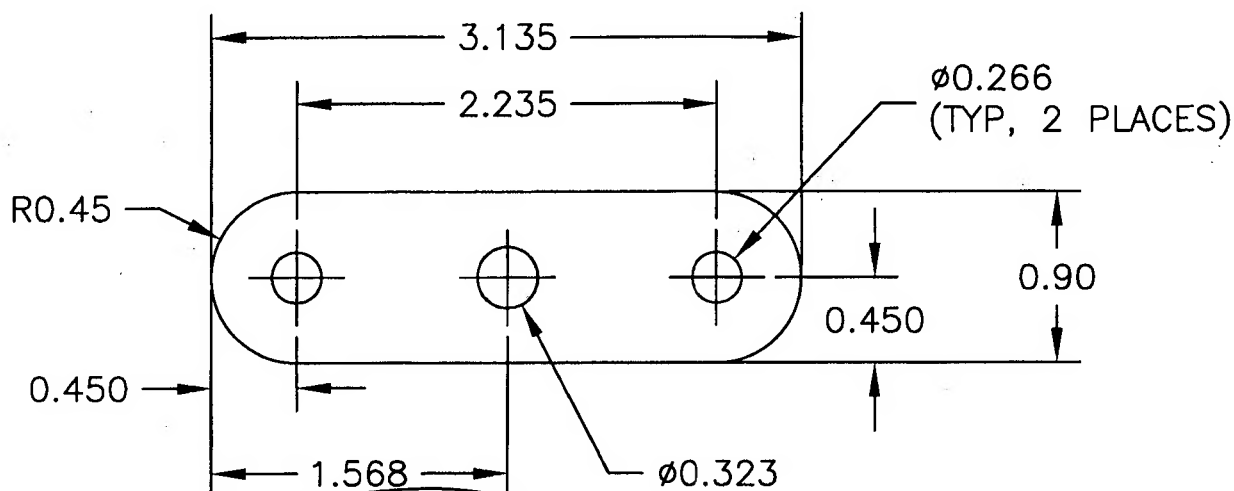
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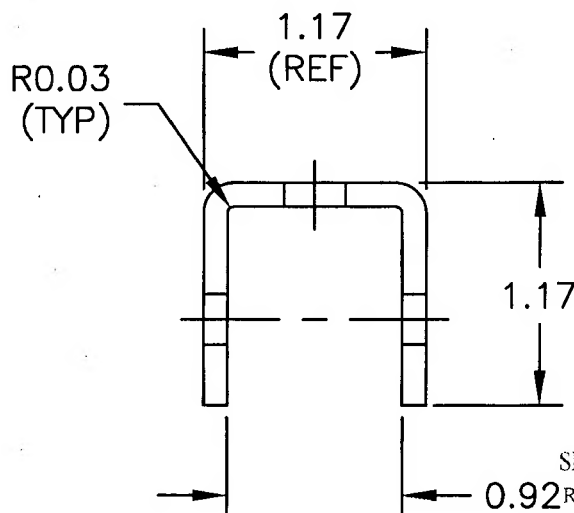
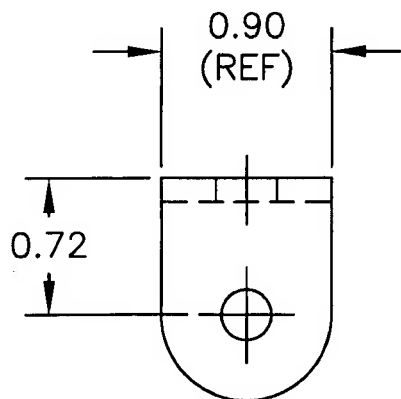
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. B SHEET 4 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1

**D3516-11F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)

RELEASED

06.11.28

**D3516-11 CLEVIS BENDING DETAIL**

- 1) MATERIAL: MAKE FROM D3516-11F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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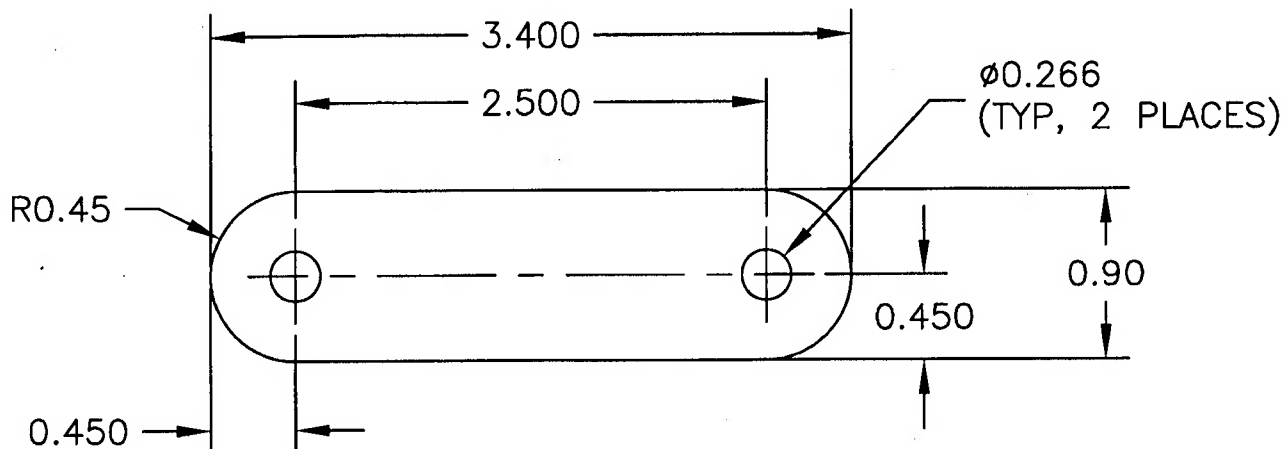
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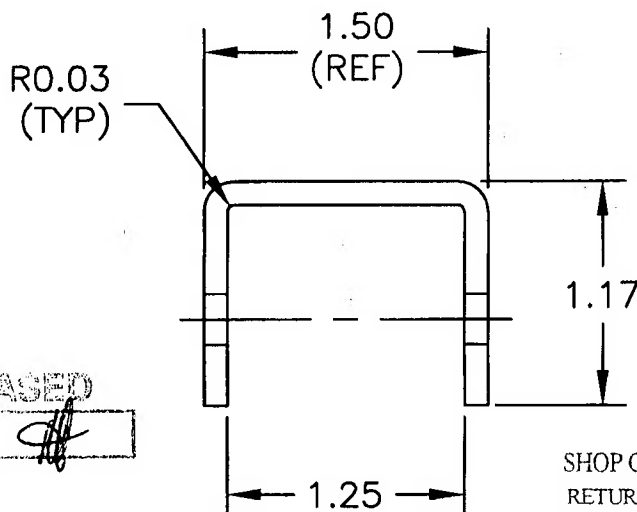
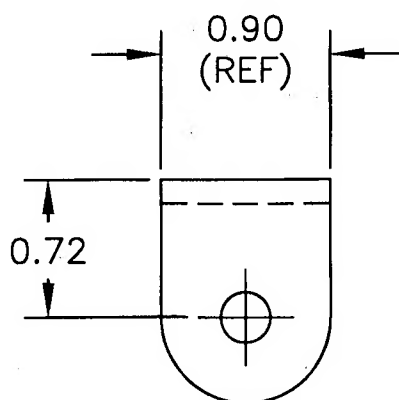


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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-13F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



RELEASED

06.11.28

D3516-13 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-13F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI '018 UNLESS OTHERWISE NOTED

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